

Work Order ID 155132

Monday, January 09, 2017 11:28:05 AM

155132

Page 1

Item ID: D350-604-041
Revision ID: URF 16-567
Item Name: Rear Locker Extender

Accept

N900040100

Setup Start ***NS1***
Stop ***NS2***

Start Date: 3/31/2017 Start Qty: 1.00 ***1***
Required Date: 5/1/2017 Req'd Qty: 1.00 ***1***

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: DAS 21 9-89 Date: **JAN 12 2017** Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2273	UR M 17/6/12								
D350-604-041	C U/R 17/6/13								

100	Document Control	0.00							
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100

DC

Doc.Control -USB or Paperwork

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile and create labels per PPP D350-604-041

CHG009

CHG010

DAS
21
9-89

see attachment

110

110

Purchasing

Purchasing

PURCHASING

Memo

0.00

Issue P/O:

34972

Description: D350-604-041 Rear locker extender.

Manufacture as per dwg D2273

Supplier: FDC Composites Inc.

Certification of Conformity and process sheet required.

***EXTREME CARE MUST BE TAKEN TO PROTECT THE SURFACES OF
THE REAR LOCKER. THE SURFACES MUST BE SMOOTH AND FREE
FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR
DENTS.***

MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE

DAS
28
9-89

JUL 03 2017

1 JAN 17 2017

DAS
13
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					

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120

Receive & Inspect for Damage & Mat'l Certs

0.00

120

Packaging

Packaging:

Memo

0.00

Packaging

Ensure a copy of Certification of Conformity and process sheet from Carbon-by-Design is attached.

DO NOT STACK REAR LOCKERS OR ANYTHING ON THEM

1X 80175-4

130

QC6- Inspect dimensions to drawing

0.00

130

QC

Memo

0.00

Quality Control

Check hole locations to template. DT 8824 Check process sheet and audit.

① 1705-05

DAS
9
9-89

PTO

140

0.00

140

Small Fab

Memo

0.05

Small Fab

1- INSTALL DECALS AS PER DWG

DAS
28
9-89

JUL 03 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: <u>155132</u> Part No. <u>D350-604-041</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
See UCL 17-6433				New part received on 17.6.8 and inspected. FDC ID => DAE001-130 Lot => 2017-03-06 PD 17.06.13				Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER :									

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--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150 QC5- Inspect part completeness to step on W/O 0.00

150

QC

Memo

0.00

Quality Control

DAS
27
9-89

JUL 03 2017

155 Pick Kit 0.00

155

Packaging

Memo

0.00

Packaging

DO NOT STACK REAR LOCKERS OR ANYTHING ON THEM

DAS
27
9-89 MAY 16 2017

158 QC4- 100% Inspect kits for completeness 0.00

158

QC

Memo

0.01

Quality Control

DAS
28
9-89

JUL 03 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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							Completed By		
							Lead hand / Supervisor Approval Verification		
					QC / QA Coordinator Approval				

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐	☐	Pressure/Forced ☐	☐	Temperature/Cure ☐	☐
Design ☐	☐	Operator ☐	☐	Bending ☐	☐	Set-up ☐	☐
Doc/Data ☐	☐	Offset/Setup ☐	☐	Centre Not Concentric ☐	☐	BOM/Route ☐	☐
Equip/Tooling ☐	☐	Supplier ☐	☐	Cracks ☐	☐	Broken/Damage/Defect ☐	☐
Handling/Pre ☐	☐	Training ☐	☐	Crimp/Kink/Ripple/Wave ☐	☐	Inspection Incomplete/Unqualified ☐	☐
Material ☐	☐	Use for Testing ☐	☐	Cuffs ☐	☐	Contamination ☐	☐
Internal Transport ☐	☐	Poor Information ☐	☐	Crushing ☐	☐	Countersink ☐	☐
Tribal Knowledge ☐	☐	Rushing ☐	☐	Heat Treat ☐	☐	Cut Too Short ☐	☐
LOA ☐	☐	Product Improvement ☐	☐	Wave/Twist in Tube ☐	☐	Instructions Incomplete/Unclear ☐	☐
Substation ☐	☐	Process Improvement ☐	☐	Marks/Chatter ☐	☐	Drill Holes ☐	☐
Past Expiry Date ☐	☐	Manufacturing Process ☐	☐	OTHER : _____ _____ _____			
Misidentified ☐	☐	Past Due ☐	☐				

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Page 4

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

0.00

160

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-604-041

Location:

PPP Rev: Fg107DAS
28
9-89

JUL 03 2017

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.02

Quality Control

DAS
21
9-89

JUL 03 2017

17/7/4 

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
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Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

Picklist Print

Monday, January 09, 2017 11:28:08 AM

Page 1

Work Order ID: 155132

155132

Parent Item: D350-604-041

D350-604-041

Parent Item Name: Rear Locker Extender

Start Date: 3/31/2017

Required Date: 5/1/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:Q03.12.01ReformatKJ/RF IPP REV:R
12.02.07 AS PER ECN12-521 DD verf:JLM IPP REV:S 12.04.04
AS PER DWG REV.B DD VERF:EC IPP REV:T 13.09.12 as per
CHG006/ECN13-616 DDVERF:JLM IPP REV:U 14.05.28 as per
chg008/ecn14-563 DD verf:JLM IPP REV:V 15.03.13 remove cam lock and
washerDD verf:JLM IPP REV:W 15.03.25 ECN15-545 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D350-604-041P

Purchased

No

110

Each

0.0000

1

1

D350-604-041P

Rear Locker Extender

D2268

Manufactured

No

140

Each

13.0000

1

1

D2268

Placard

DAS
28
9-89

Location

Loc Qty

Loc Code

ST006

13

147069

7

6/13/2017

148553

6

7/22/2017

D2728-1

Manufactured

Yes

140

Each

-1.0000

1

1

D2728-1

Dart Logo Label Small

D2269

Manufactured

No

155

Each

8.0000

1

1

D2269

Placard

DAS
28
9-89

Location

Loc Qty

Loc Code

ST006

8

147070

2

6/13/2017

148588

6

7/22/2017

1 X 801754

162755 DAS SCRAP 27 9-89 MAY 16 2017

DAS
27
9-89

161468 DAS 27 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Picklist Print

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Work Order ID: 155132

155132

Parent Item: D350-604-041

D350-604-041

Parent Item Name: Rear Locker Extender

Start Date: 3/31/2017

Required Date: 5/1/2017

Start Qty: 1.00

Required Qty: 1.00

D5062-041

Manufactured No

155 Each

16.0000 1 1

D5062-041

Bracket Assembly

**

DAS
6
9-89

MAY 16 2017
DAS
27
9-89

Location

Loc Qty

Loc Code

ST147

16

145920

16

DAS
28
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

TABLE 1

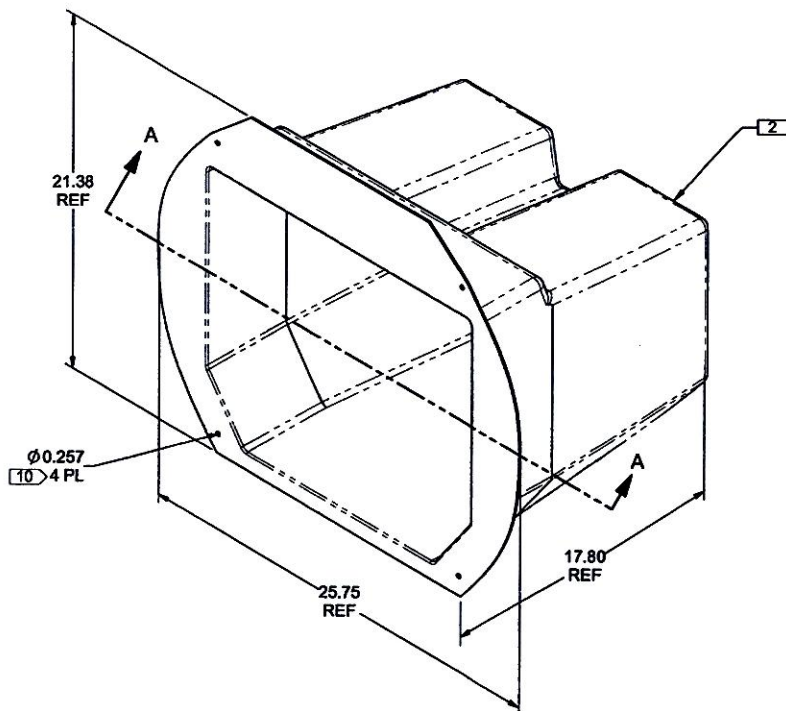
POSITION	MATERIALS
1	TOOL SURFACE
2	GELCOAT
3	3/4 oz CHOPPED STRAND MAT
4	7725 FIBER GLASS
5	7725 FIBER GLASS
9	7725 FIBER GLASS
10	PRIMER

TABLE 2

POSITION	MATERIALS
1	TOOL SURFACE
2	GELCOAT
3	3/4 oz CHOPPED STRAND MAT
4	7725 FIBER GLASS
5	7725 FIBER GLASS
6	7725 FIBER GLASS
7	7725 FIBER GLASS
8	7725 FIBER GLASS
9	7725 FIBER GLASS
10	PRIMER

NOTES:

- 1) MATERIAL: SEE TABLE 3
 2) FINISH: SEE TABLES 1, 2, & 3
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 7) WEIGHT: 5.5-7.5 lbs
 8) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
 9) LAYUP USING DT9871 MOLD. WET LAYUP WITH BAG/VACUUM
 10) TRIM & DRILL PER DT9905. OPEN HOLES TO Ø0.257
 11) CONSTRUCTION: SEE TABLES 1 & 2
 12) MATTE TO HOLD DOWN CORNERS AS REQUIRED



D2273 REAR LOCKER EXTENDER

TABLE 3

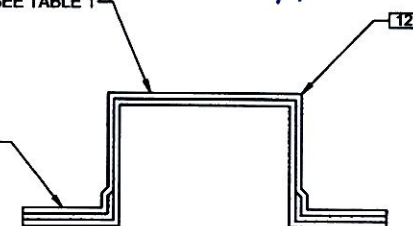
MATERIAL USED	DESCRIPTION
GELCOAT	55X3535 WHITE GELCOAT
FIBER GLASS MAT	OWENS CORNING 3/4 oz CHOPPED STRAND MAT
FIBER GLASS CLOTH	HEXCEL 7725 FIBER GLASS
RESIN SYSTEM	DION 7704
PRIMER	TEMPO 4500-PB-23G (GREEN)

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER

NO. 155132 MLJ
 1701-12

SEE TABLE 1

SEE TABLE 2



SECTION A-A

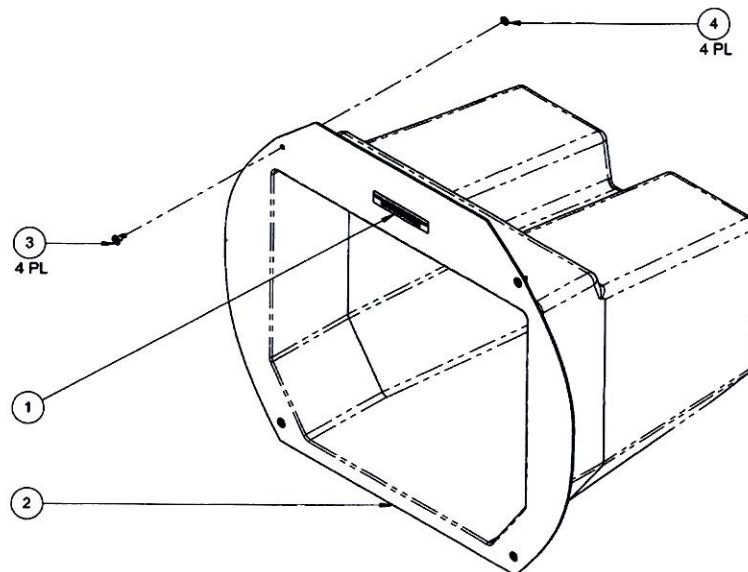
M	CHANGE GELCOAT TO 55X3535 WHITE GELCOAT, REMOVE PAINT FINISH OPTION (NOTE 2)	DB	16.05.19
L	ADD PAINT OPTION (NCR 15-5408)	CP	15.10.19
K	LAYUP AND MAT'L PER FDC COMPOSITES PROCESS	CP	15.03.12
J	CHANGED GELCOAT TO 4314-001 DURA FR WHITE	ML	13.12.10
I	CHANGE GELCOAT TO POLYCOR 2330PAWK745	SFM	13.08.13
H	CHANGE MATERIAL & MANUFACTURING PROCESS	DC	13.03.15
G	ADD MANUFACTURING OPTION B, ZN B5-1	DC	12.08.08
F	PRIMER LE 3404-S/LE 1175-S WAS 1144-S, ZN A6-1	DC	12.02.27
E	CHANGED SURFACE FINISH FROM 944W005 GELCOAT TO 2330PAWK745 GELCOAT, ZN A7-1. UPDATED DWG TO CURRENT STANDARDS.	DC	12.02.02
D	REMOVE EPOCAST, ADD SURFACE FINISH	CP	02.04.01
C	CLARIFY MATERIAL, LAYUP, AND TOOLING	RF	02.01.30
B	RE-DRAWN	MM	96.05.27
REV.	DESCRIPTION	BY	DATE

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2273 REV. M SHEET 1 OF 1 SCALE 350 REAR LOCKER EXTENDER NTS COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DRAWN	DB		
CHECKED	ML		
MFG. APPR.	DD		
APPROVED	WM	DATE 16.05.19	
DE APPR.	DS		

RELEASED
 2017-01-11
 ECU 17-501

APPROVED

ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
	X	D350-604-041	REAR LOCKER EXTENDER ASSEMBLY
1	1	D2268	PLACARD
2	1	D2273	REAR LOCKER EXTENDER
3	4	2600-6	CAMLOCK STUD
4	4	2600-LW	RETAINING WASHER



D350-604-041 REAR LOCKER EXTENDER ASSEMBLY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 5.5 to 7.5 lbs
 - 8) INSTALL D2268 PLACARD IN LOCATION SHOWN, CENTERED ON FLANGE

C	REMOVE D2728-1, D2729-1 DECALS (ZN C5-1) REVISED RELATED NOTES, UPDATED PART WEIGHT	ML	13.12.16
B	INCORPORATE DSI 9470 (ZN D7-1), UPDATE DWG TO CURRENT STANDARDS. ADD D2728-1 PLACARD AND ORIENTATION NOTE (ZN C3-1), ADD D2729-1 (ZN C5-1).	DC	12.02.07
A	NEW ISSUE	CP	02.04.01
REV.	DESCRIPTION	BY	DATE
DESIGN	DW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D350-604-041 REV. C SHEET 1 OF 1 TITLE RLE ASSY SCALE NTS COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. NO IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	ML		
CHECKED	AP		
MFG. APPR.	JLM		
APPROVED	MP		
DE APPR.	DS		
DATE	14.01.02		

PAGE 1 OF 1

Part Number: D350-604-041

Description: REAR LOCKER EXTENDER

[illegible]



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO34972**

Purchase Order Date 1/17/2017

PO Print Date 1/31/2017

Page Number 2 of 3

Order From : VC-FDC01
FDC COMPOSITES INC.
45 CHEMIN DE L'AEROPORT
LOCAL 26
ST-JEAN-SUR-RICHELIEU, QUEBEC J3B 7B5

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 450-357-1344 ext303
Ship To Contact
Ship To Phone
Ship Via: Journey Freight collect
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

3	D350-604-041P	Rear Locker Extender	5/1/2017 Yes 5/1/2017	1.00 Each	\$705.00	\$705.00
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AS PER DWG D2273 REV. M / D350-604-041 REV. C
B155130
PLEASE NOTE REARLOCKER UNDER NEW REV. M

Line Total: \$705.00

4	D350-604-041P	Rear Locker Extender	5/1/2017 Yes 5/1/2017	1.00 Each	\$705.00	\$705.00
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AS PER DWG D2273 REV. M / D350-604-041 REV. C
B155131
PLEASE NOTE REARLOCKER UNDER NEW REV. M

Line Total: \$705.00

5	D350-604-041P	Rear Locker Extender	5/1/2017 Yes 5/1/2017	1.00 Each	\$705.00	\$705.00
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AS PER DWG D2273 REV. M / D350-604-041 REV. C
B155132
PLEASE NOTE REARLOCKER UNDER NEW REV. M

DAS
9
9-89

SP/7-5-4

PO Instructions: NOTE: NO BILLING PRIOR TO SHIPPING,

Note:

1/31/2017

FDC Composites inc.
45, Chemin de L'Aéroport
Local 26
Saint-Jean-sur-Richelieu (QC)
J3B 7B5
Tel. : 450 357-1344

Shipping Order

01/05/2017

Order : 2623
Reference : PO 34972/1-5

Customer: Dart

DART AEROSPACE
1270 Aberdeen Street
Hawksbury, ON
K6A 1K7

Ship To
DART AEROSPACE LTD.
1270 Aberdeen Street
Hawksbury, ON
K6A 1K7
Tel.: 1 613 632-9577

Item No.	Description	Qty	Qty. Delivere	B/O Qty
D350-604-041P	REAR LOCKER EXTENDER PO item: 34972/1 FDC ID : DAE001-107 LOT : 2017-02-21 As per DWG.D2273 Rev. M B155127	1	_____	_____
D350-604-041P	REAR LOCKER EXTENDER PO item: 34972/2 FDC ID : DAE001-109 LOT : 2017-02-21 As per DWG.D2273 Rev. M B155129	1	_____	_____
D350-604-041P	REAR LOCKER EXTENDER PO item: 34972/3 FDC ID : DAE001-114 LOT : 2017-02-23 As per DWG.D2273 Rev. M B155130	1	_____	_____
D350-604-041P	REAR LOCKER EXTENDER PO item: 34972/4 FDC ID : DAE001-124 LOT : 2017-03-01 As per DWG.D2273 Rev. M B155131	1	_____	_____
D350-604-041P	REAR LOCKER EXTENDER PO item: 34972/5 FDC ID : DAE001-133 LOT : 2017-03-07 As per DWG.D2273 Rev. M B155132	1	_____	_____

D/S
9
9-89

80175-4

Shipping : _____

Package No : _____

Merchandise Received: _____

Ref. : _____



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CERTIFICATE of CONFORMITY

Customer Name: Dart Aerospace.

Customer P/O Number: 34972

Rev. NC

<u>PO Item</u>	<u>Qty</u>	<u>Part number</u>	<u>Dwg number</u>	<u>Description</u>	<u>Dart ID</u>	<u>FDC ID</u>	<u>Lot</u>
1	1	D350-604-041P	D2273 Rev M	350 Rear Locker Extender	B155127	DAE001-107	2017-02-21
2	1	D350-604-041P	D2273 Rev M	350 Rear Locker Extender	B155129	DAE001-109	2017-02-21
3	1	D350-604-041P	D2273 Rev M	350 Rear Locker Extender	B155130	DAE001-114	2017-02-23
4	1	D350-604-041P	D2273 Rev M	350 Rear Locker Extender	B155131	DAE001-124	2017-03-01
5	1	D350-604-041P	D2273 Rev M	350 Rear Locker Extender	B155132	DAE001-133	2017-03-07

I hereby certify that the workmanship, material and the processes used in the manufacture of the above part(s) supplied are in accordance with the requirements of the applicable Purchase Order.

Signature:

Marjorie G
Marjorie Geoffrion, Quality Inspector

Date: 2017-05-01



# LOT	20140101
# SÉRIE(ID)	DAE001-133

Nom de Gamme :	Rear locker extender - DART
# de Gamme (et rev.) :	DAE001 Rev. E
Nom pièce - Client :	350 Rear locker extender - DART AEROSPACE
# de Dessins (et rev.) :	D2273 Rev. M

B155132

Fiche suiveuse

[10-50]	PRÉPARATION	Moule, Espace de travail, Matières premières, Consommables	#21 02 MAR. 2017
[60-80]	FINITION	Appliquer Gelcoat, Inspecter	#3 07 MAR. 2017
[90-140]	MOULAGE	Laminer, Démouler, Inspecter	#23 07 MAR. 2017
[150-190]	USINAGE	Percer, Découper, Ébavurer, Inspecter, Sabler	#30 9 MAR. 2017
[200-230]	FINITION	Primer, Inspection	#3 28 MAR. 2017
240	EXPÉDITION	Emballer, Expédier	#8 1 MAI 2017

Gamme préparée par :	Guillaume G.Jasmin
Gamme vérifiée par :	Francis Lavigne-Larente
Gamme approuvée par :	Maxime Gagné
Date d'émission :	2015-01-14

Gamme révisé préparée par :	Pascal Séguin
Gamme révisé vérifiée par :	Karim Malihi
Gamme révisé approuvée par :	Michel Morin
Date de révision :	2017-02-22

Informations à remplir :

Cases grises pâles

Inspection :

Approbation Qualité
Avant de produire le CofC, toutes les étapes et les
informations requises des gammes subséquentes reliées à
ce produit ont été complétées et remplies

#8



Reu

1 MAI 2017

Matières premières

Résine	1028612	2017-05-17	Dion 7704
Norox (Résine)	41049	2017-08-01	MEKP-9
Norox (Gelcoat)	41049	2017-08-01	MEKP-9
Gelcoat blanc	702407	2017-03-27	55X-3535
Mat ¾ oz/pi²	15851100174-1	N/A	¾ oz Chopped Strand Mat (Owens Corning Or Equivalent)
Fibre de verre 7725	4451515	N/A	Hexcel 7725 Fiber Glass
Apprêt (Primer) (Vert)	18584	2018-12-31	Tempo 4500-PB-23G (Vert)
Durcisseur pour apprêt (hardener)	18317	2018-05-01	Tempo 4500-C-23
Attache mécanique (Camloc)	508980	N/A	2600-5
Rondelle de retenue pour Camloc	1674905	N/A	2600-LW

Moule : MOU306 ou MOU309	FMS	Sarrau
Pompe à vide	55NC	Lunettes de sécurité
Jig de découpe et perçage CNC 5 axes	Peel ply	Soulier de protection
Jig de finition et d'inspection : GAB355	Film perforé	Gants
	Bleeder breather	Masques à cartouches
Pince pour installer Camloc : OUT951	Bag big blue	
Outil pour installer rondelle de retenue : OUT952	Ruban scellant (Dum Dum)	

Annexe 1
Formulaire de résine (RES-DAE001)

MPS-300-93-31-007-NC	Démoulage 55NC
MPS-300-93-31-058-A	Composite part inspection
MPS-300-93-31-020-B	Edge finish after trimming
MPS-300-93-31-097-NC	Epoxy - Polyamide primer
MPS-300-93-31-084-NC	Protection et entreposage des pièces

Suivi des révisions

A	Révision d'une OP inspection, Ajout nouveaux moules et retrait d'un type de primer	2015-03-04	Guillaume G.Jasmin
B	Ajout des conformateurs, du gabarit GAB355, de l'installation des camlocs, inspection du poids et identification finale	2015-03-25	Guillaume G.Jasmin
C	Mise à jour de la case approbation qualité page 1	2015-04-02	Guillaume G.Jasmin
E	Changement de gelcoat, modification du format de la gamme, révision complète de la gamme	2017-02-22	Pascal Séguin

PRÉPARATION

10	<u>Remplir les informations requises sur la première page (cases gris pâle)</u> - Demander au coordonnateur de production (ID) - Inscrire les heures et les dates d'entrée et de sortie de département	!	#23 02 MAR. 2017 #21	E: R:
20	<u>Découper la fibre et les périssables (Peel ply, sac étanche...) selon l'ANNEXE 1</u> - ACHEMINER et REMPLIR la section « Matière premières » pour : - Fibre de verre 7725 - Mat ¾ oz	Annexe 1	#21 02 MAR. 2017 #23 02 MAR. 2017	E: R:
30	<u>Préparer la résine selon RES-DAE001 (Gamme de formulation de résine)</u> ACHEMINER et REMPLIR la section « Matière premières » pour : - Résine - Norox	RES-DAE001 !	#28 7 MAR. 2017	E: R:
40	<u>Péparer le moule</u> - Cochez le moule utilisé : MOU306 ☐ / MOU309 ☒ ☐ Nettoyer et traiter le moule ☒ Poser le Masking tape <u>Si nécessaire, traiter le moule au 55NC</u> Faire le test de pelage, s'il ne passe pas, appliquer une couche de 55NC et refaire le test.	Annexe 1 MOU306 ou MOU309 MPS-300-93-31-007	#26 07 MAR. 2017	E: R:

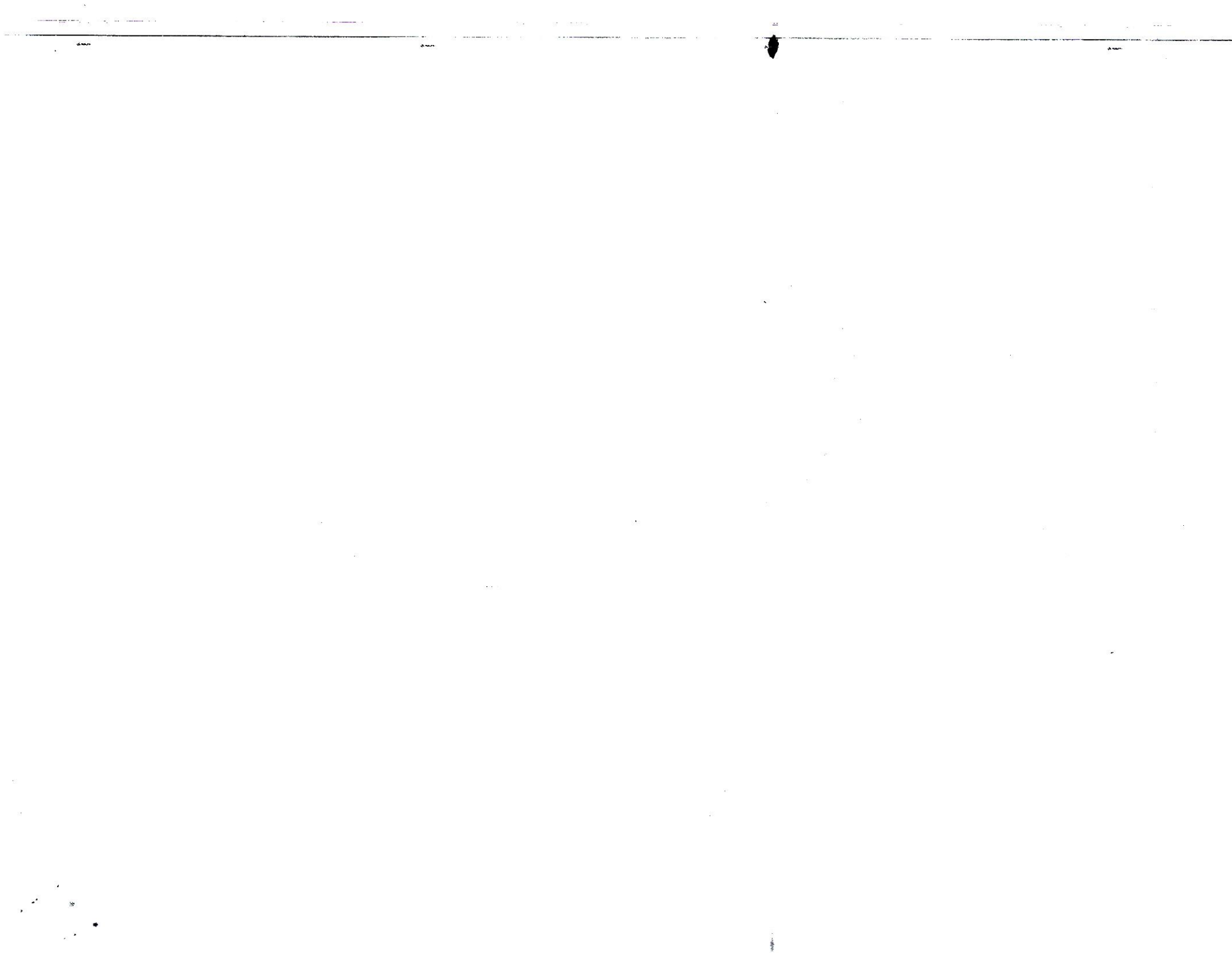
50	<u>Préparer l'espace de travail (pendant l'application du gelcoat)</u>					E: R:
	☐ Vérifier et préparer la pompe ☐ Préparer et distribuer les outils ☐ Protéger l'environnement de travail (tables, plancher, etc.) ☐ Vêtir l'équipement de protection personnel ☐ Partir la ventilation ☐ Vérifier l'ordre et la présence de tous les plis de fibre et des morceaux de noyau dans le sac					
	Position	Matériel	Initial employé			
	10F	¾ oz Chopped strand MAT	hy			
	20F	7725 Fibre de verre	hy			
	30F	7725 Fibre de verre	hy			
	40R	7725 Fibre de verre	hy			
	50R	7725 Fibre de verre	hy			
	60R	7725 Fibre de verre	hy			
	70F	7725 Fibre de verre	hy			

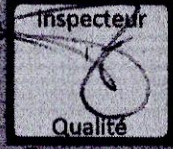
FINITION				
60	<u>ACHEMINER et REMPLIR la section « Matière premières » pour :</u> • Gelcoat blanc 55X-3535 • Norox MEKP-9			#28 7 MAR. 2017 E: R:
70	<u>Appliquer le Gelcoat (18 - 22 mils)</u> Heure d'application: 11 h 30 min		Annexe 1	#3 07 MAR. 2017 E: R:
80	<u>Vérification de l'épaisseur du gelcoat lorsqu'encore humide</u>		Gauge d'épaisseur	E: R:



MOULAGE

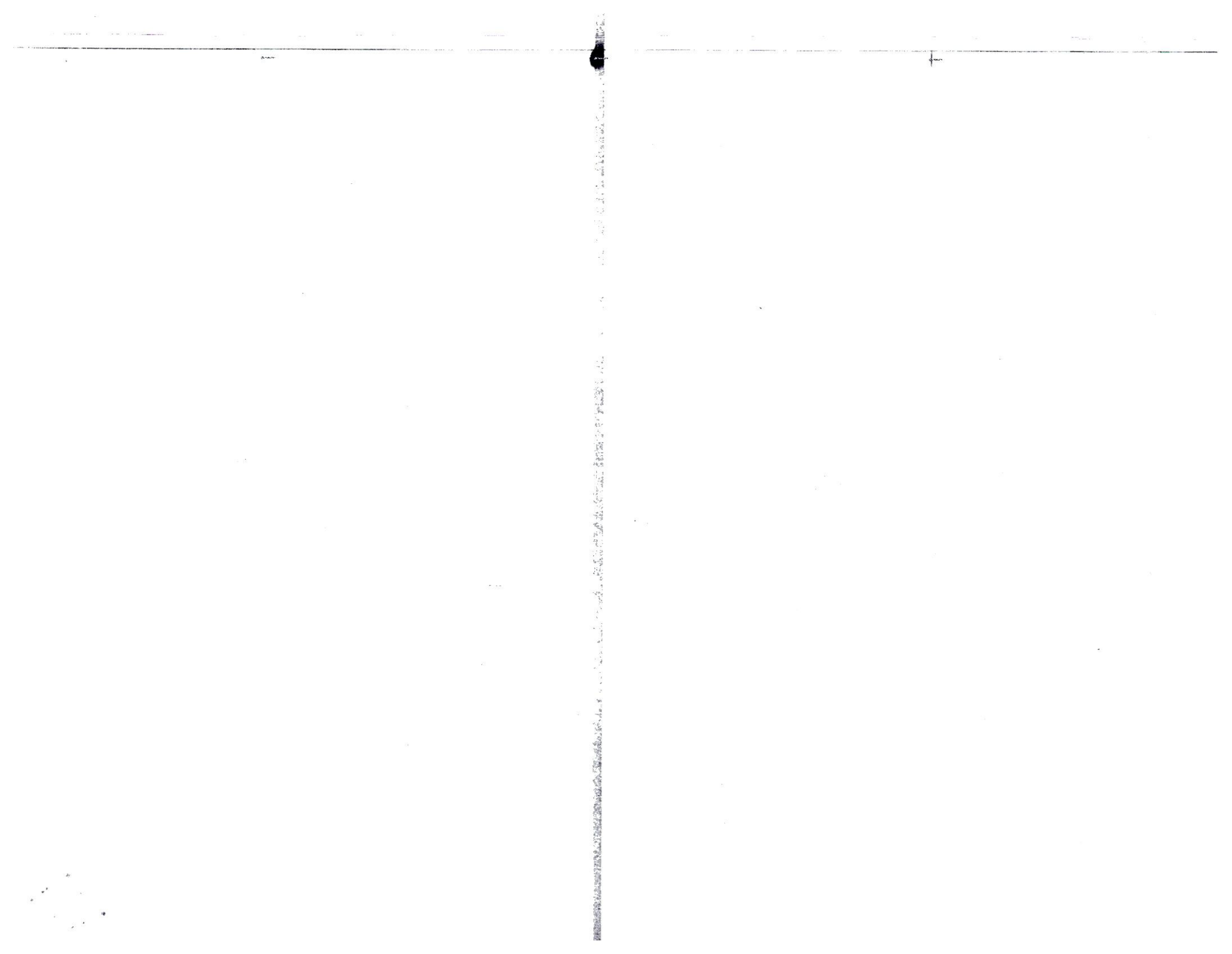
90	Points d'inspection Inspecteur Qualité ou Chef d'Équipe : ☒ Qualité de l'application du gelcoat : Uniforme et esthétique ☒ Donner l'approbation pour que la pièce puisse être laminée (le gelcoat est « amoureux » ou « tack free »)		 2017-03-07																															
100	LAMINER <table border="1" data-bbox="219 653 938 940"> <thead> <tr> <th>Position</th> <th>Matériel</th> </tr> </thead> <tbody> <tr> <td>10F</td> <td>¾ oz Chopped strand MAT</td> </tr> <tr> <td>20F</td> <td>7725 Fibre de verre</td> </tr> <tr> <td>30F</td> <td>7725 Fibre de verre</td> </tr> <tr> <td>40R</td> <td>7725 Fibre de verre</td> </tr> <tr> <td>50R</td> <td>7725 Fibre de verre</td> </tr> <tr> <td>60R</td> <td>7725 Fibre de verre</td> </tr> <tr> <td>70F</td> <td>7725 Fibre de verre</td> </tr> </tbody> </table> CONSOMMABLE <table border="1" data-bbox="219 1035 938 1178"> <tbody> <tr> <td>10F</td> <td>Peel Ply</td> </tr> <tr> <td>20F</td> <td>Release film non perforé</td> </tr> <tr> <td>30F</td> <td>Bleeder / Breather</td> </tr> <tr> <td>50F</td> <td>Bagging bleu</td> </tr> </tbody> </table> ☐ S'assurer que tous les plis dans le tableau ont été laminés ☐ S'assurer que tous les conformateurs (Qte 9) sont en place par-dessus le Bleeder/Breather <table border="1" data-bbox="219 1339 1003 1461"> <tbody> <tr> <td>Heure début laminage</td> <td>11 h 50 min</td> </tr> <tr> <td>Heure mise sous-vide (sac scellé)</td> <td>12 h 45 min</td> </tr> <tr> <td>Intensité du vide (25 inHg)</td> <td>29</td> </tr> </tbody> </table>	Position	Matériel	10F	¾ oz Chopped strand MAT	20F	7725 Fibre de verre	30F	7725 Fibre de verre	40R	7725 Fibre de verre	50R	7725 Fibre de verre	60R	7725 Fibre de verre	70F	7725 Fibre de verre	10F	Peel Ply	20F	Release film non perforé	30F	Bleeder / Breather	50F	Bagging bleu	Heure début laminage	11 h 50 min	Heure mise sous-vide (sac scellé)	12 h 45 min	Intensité du vide (25 inHg)	29	Annexe 1 GAB356 à GAB364 (Qte 9)	#19 07 MAR. 2017 #26 07 MAR. 2017 #21	E : R :
Position	Matériel																																	
10F	¾ oz Chopped strand MAT																																	
20F	7725 Fibre de verre																																	
30F	7725 Fibre de verre																																	
40R	7725 Fibre de verre																																	
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Heure début laminage	11 h 50 min																																	
Heure mise sous-vide (sac scellé)	12 h 45 min																																	
Intensité du vide (25 inHg)	29																																	
	#23 #26 LAISSER POLYMÉRISER la pièce sous vide pendant 2h 07 MAR. 2017 07 MAR. 2017	#19 07 MAR. 2017	# N/A 07 MAR. 2017	E : R :																														
120	DÉMOULER et IDENTIFIER la pièce ☒ Brancher le système d'air comprimé ☒ Écrire le numéro de pièce et la date sur un collant – # de lot (date de début) – # de série ID Ex : (AAAAMMJJ) – (DAE001-XXX) ☒ Placer la pièce sur la table d'inspection	Annexe 1	#26 07 MAR. 2017 #19 07 MAR. 2017	E : R :																														



130	Point d'inspection (inspecteur qualité) : ☒ Identifier la présence de surplus de résine ☒ Identifier la présence de bulles d'air ☒ Identifier la présence de zone sèche ☒ Identifier la présence de plis dans la fibre	MPS-300-93-31-058		
140	Nettoyer le moule - Enlever la résine durcie tout le tour du moule avec une spatule en plastique pour ne pas endommager le moule Si nécessaire, nettoyer le moule avec un chiffon légèrement humecté de nettoyant à moule (PMC) NE PAS TROP APPLIQUER DE "PMC"	Spatule en plastique	#19 07 MAR. 2017 #26 07 MAR. 2017	E : R :

USINAGE

150	PERÇAGE ET DÉCOUPE CNC 5 axes : Utiliser le gabarit d'usinage et le programme d'usinage à l'emplacement suivant : Z:\PROGRAMMES\Dart Aerospace\Dart Aerospace Rear Lockers\21-Dessins & Outillage\Outillage\usinage 5 axes	Annexe 1	#50 9 MAR. 2017	E : R :
160	SABLAGE : - INSTALLER le Gabarit de finition et d'inspection GAB355 - SABLER la pièce jusqu'à arriver à la dimension du Gabarit GAB355 - ÉBAVURER les arêtes vives	GAB355 Annexe 1 MPS-300-93-31-020	N/A	E : R :
170	Point d'inspection (inspecteur qualité) : ☒ Plier les flanges (rebords) afin de s'assurer que le Gelcoat ne craque pas. (Voir Annexe 1 pour le test) ☒ Vérifier la conformité de la pièce (Dimensions) selon le no. de dessin et selon le MPS-300-93-31-058	Annexe 1 MPS-300-93-31-058		
180	SABLER légèrement l'extérieur de la pièce Papier 120 à 320 grains		#19 13 MAR. 2017	E : R :
190	NETTOYER les surfaces extérieures		#19 13 MAR. 2017	E : R :

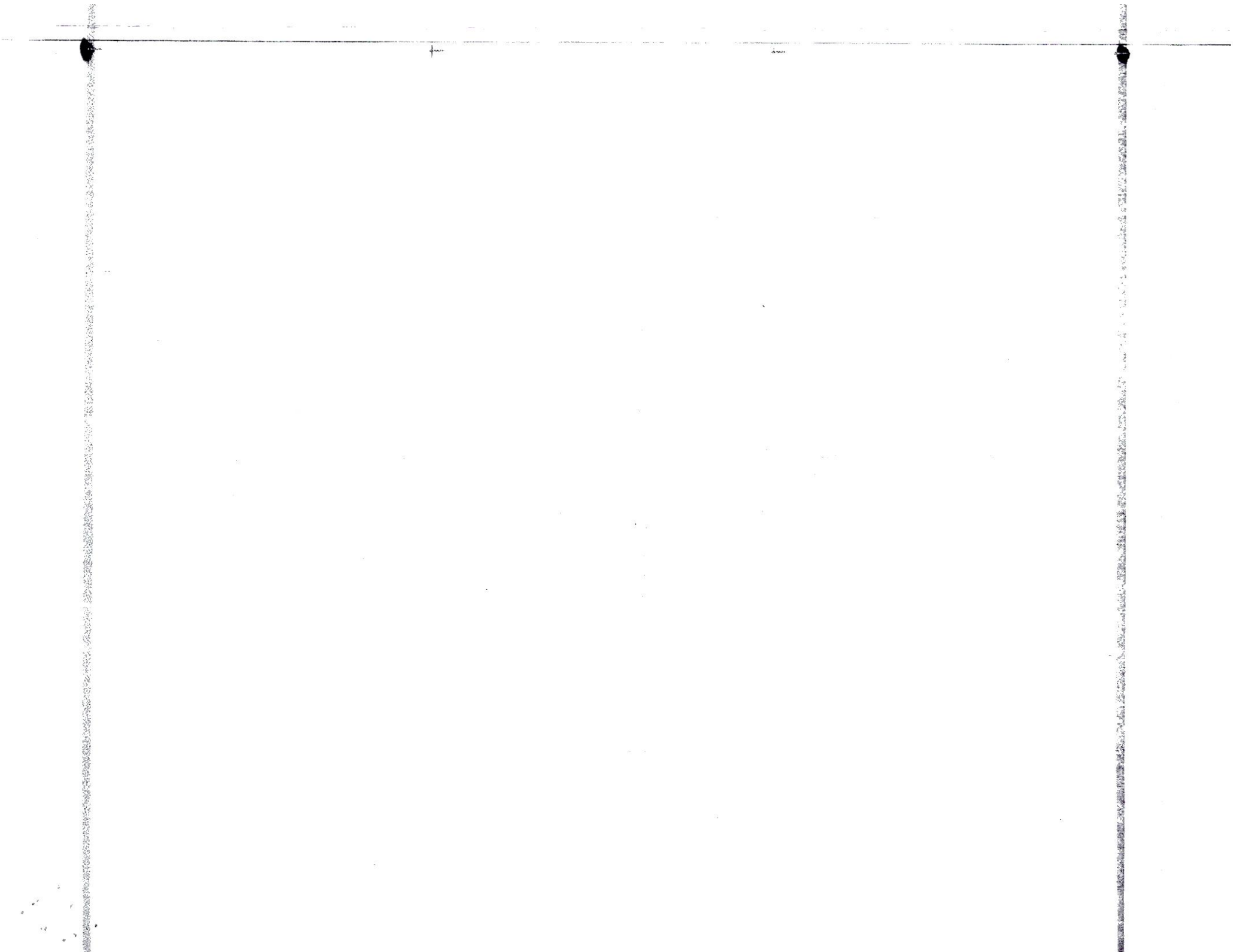


FINITION

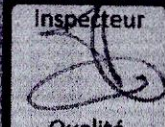
200	APPLIQUER le primer 2 couches d'environ 10 mils chacune	MPS-300-93-31-097	#3 mms 28 APR 2017	E: R:
210	Protéger le gelcoat Découper une pellicule de plastique protecteur bleu et la coller sur le rebord et à l'intérieur de la partie blanche (Gelcoat) (Voir Annexe 1)	Annexe 1	#19 1 MAI 2017	E: R:
220	INSTALLER les attaches mécaniques (Camlocs) (Qte 4) - Utiliser les pinces spécialisées (OUT951) pour insérer les Camlocs dans les trous - Utiliser l'outil spécialisé (OUT952) pour installer les rondelles de retenues	Annexe 1 Pince à Camloc (OUT951)	#19 1 MAI 2017	E: R:
230	Inspection finale : - Validation de la finition (pinholes, surface inégale, etc...) - Vérifier s'il y a un panneau de contrôle relié à la pièce - Étamper le carré dans le coin inférieur droit de la première page - Poids de la pièce : <u>6.2</u> (LBS)	Annexe 1 MPS-300-93-31-058		

EXPÉDITION

240	Identifier, emballer et expédier Identification selon le document DART QSI044 à l'emplacement suivant : Z:\PROGRAMMES\Dart Aerospace\Dart Aerospace Rear Lockers\22-Gammes de Fabrication\In process	MPS-300-93-31-084	#8 1 MAI 2017	E: R:



FINITION

200	APPLIQUER le primer 2 couches d'environ 10 mils chacune	MPS-300-93-31-097	28 MAR 2017	E: R:
210	<u>Protéger le gelcoat</u> Découper une pellicule de plastique protecteur bleu et la coller sur le rebord et à l'intérieur de la partie blanche (Gelcoat) (Voir Annexe 1)	Annexe 1	#19 1 MAI 2017	E: R:
220	<u>INSTALLER les attaches mécaniques (Camlocs) (Qte 4)</u> - Utiliser les pinces spécialisées (OUT951) pour insérer les Camlocs dans les trous - Utiliser l'outil spécialisé (OUT952) pour installer les rondelles de retenues	Annexe 1 Pince à Camloc (OUT951)	#19 1 MAI 2017	E: R:
230	<u>Inspection finale:</u> - Vérification de la finition (sangles, surface inégale, etc...) - Vérifier qu'il y a un panneau de contrôle relié à la pièce - Étamper le carré dans le coin inférieur droit de la première page - Poids de la pièce: <u>6.6</u> (LBS)	Annexe 1 MPS-300-93-31-052	Inspecteur  Qualité	

EXPÉDITION

240	Identifier, emballer et expédier Identification selon le document DART QSI044 à l'emplacement suivant : Z:\PROGRAMMES\Dart Aerospace\Dart Aerospace Rear Lockers\22-Gammes de Fabrication\In process	MPS-300-93-31-084	#8 1 MAI 2017	E: R:
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FDC Composites inc.
45, Chemin de L'Aéroport
Local 26
Saint-Jean-sur-Richelieu (QC)
J3B 7B5
Tel.: 450 357-1344

Shipping Order 06/06/2017

Order : 2638
Reference : PO 34972/1-5

Customer: Dart

DART AEROSPACE
1270 Aberdeen Street
Hawksbury, ON
K6A 1K7

Ship To
DART AEROSPACE LTD
1270 Aberdeen Street
Hawksbury, ON
K6A 1K7
Tel.: 1 613 632-9577

Item No.	Description	Qty	Qty. Delivere	B/O Qty
D350-604-041P ✓	REAR LOCKER EXTENDER PO item: 34972/5 ✓ FDC ID : DAE001-130 ✓ LOT : 2017-03-06 As per DWG.D2273 Rev. M B155132 Replacement part for DAE001-133 Lot: 2017-03-07 CAD CURRENCY NET 30 DAYS	1		

SP17-6-9.

Shipping : _____
Package No : _____
Merchandise Received : _____

Ref. : _____



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CERTIFICATE of CONFORMITY

Customer Name: Dart Aerospace.

Customer P/O Number: 34972

Revision: NC

<u>PO Item</u>	<u>Qty</u>	<u>Part number</u>	<u>Dwg number</u>	<u>Description</u>	<u>Dart ID</u>	<u>FDC ID</u>	<u>Lot</u>
1	1	D350-604-041P	D2273 Rev M	350 Rear Locker Extender	B155132	DAE001-130	2017-03-06

This part is replacement part of rear locker extender DAE001-133 lot# 2017-03-07.

I hereby certify that the workmanship, material and the processes used in the manufacture of the above part(s) supplied are in accordance with the requirements of the applicable Purchase Order.

Signature: Marjorie G
Marjorie Geoffrion, Quality Inspector

Date: 2017-06-06



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CERTIFICATE of CONFORMITY

Customer Name: Dart Aerospace.

Customer P/O Number: 34972

Rev. NC

<u>PO Item</u>	<u>Qty</u>	<u>Part number</u>	<u>Dwg number</u>	<u>Description</u>	<u>Dart ID</u>	<u>FDC ID</u>	<u>Lot</u>
1	1	D350-604-041P	D2273 Rev M	350 Rear Locker Extender	B155127	DAE001-107	2017-02-21
2	1	D350-604-041P	D2273 Rev M	350 Rear Locker Extender	B155129	DAE001-109	2017-02-21
3	1	D350-604-041P	D2273 Rev M	350 Rear Locker Extender	B155130	DAE001-114	2017-02-23
4	1	D350-604-041P	D2273 Rev M	350 Rear Locker Extender	B155131	DAE001-124	2017-03-01
5	1	D350-604-041P	D2273 Rev M	350 Rear Locker Extender	B155132	DAE001-133	2017-03-07

I hereby certify that the workmanship, material and the processes used in the manufacture of the above part(s) supplied are in accordance with the requirements of the applicable Purchase Order.

Signature: Marjorie G.
Marjorie Geoffrion, Quality Inspector

Date: 2017-05-01

Work Order ID 155132

Monday, January 09, 2017 11:28:05 AM

155132

Page 1

Item ID: D350-604-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: URF 16-567 Stop ***NS2***
 Item Name: Rear Locker Extender
 Start Date: 3/31/2017 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 5/1/2017 Req'd Qty: 1.00 ***1*** Customer:

Reference:

Approvals: Process Plan: 21 Date: **JAN 12 2017** Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2273	URF M 17/6/12								
D350-604-041	C U/R 17/1/13	MAY 16 2017	DAS	6					
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D350-604-041 CHG009 CHG010 <i>see attachment</i>								
110	PURCHASING	0.00							
110	PURCHASING								
Purchasing	Memo	0.00							
Purchasing	Issue P/O: 34972 Description: D350-604-041 Rear locker extender. Manufacture as per dwg D2273 Supplier: FDC Composites Inc. Certification of Conformity and process sheet required.								

DAS
28
9-89
JUL 03 2017

JAN 17 2017

EXTREME CARE MUST BE TAKEN TO PROTECT THE SURFACES OF THE REAR LOCKER. THE SURFACES MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.

MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE



Transport Canada Transports Canada

Department of Transport

Supplemental Type Certificate

This approval is issued to:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ontario
Canada K6A 1K7

Number: SH90-4

Issue No.: 4

Approval Date: January 31, 1990

Issue Date: February 17, 2012

Responsible Office:

Prairie and Northern

Aircraft/Engine Type or Model:

Eurocopter France AS 350 B, B1, B2, B3, BA, D
Eurocopter France AS 355 E, F, F1, F2, N, NP

Canadian Type Certificate or Equivalent:

H-83 (AS 350 Series); H-87 (AS 355 Series)

Description of Type Design Change:

Installation of Rear-Locker Extender

**Installation/Operating Data,
Required Equipment and Limitations:**

Installation of Rear-Locker Extender must be in accordance with Transport Canada Civil Aviation (TCCA) approved Dart Aerospace Ltd. Installation Drawing D350-604, revision C, dated December 6, 2011 or later TCCA approved revision.

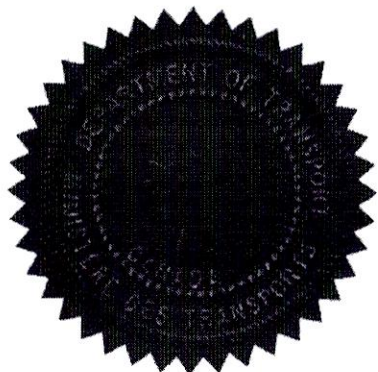
Operation of the Rear-Locker Extender must be in accordance with TCCA approved Dart Aerospace Ltd. Flight Manual Supplement FMS-D350-604, revision B, dated November 15, 2011, or later TCCA approved revision.

Maintenance of the Rear-Locker Extender must be in accordance with TCCA accepted Dart Aerospace Ltd. Instructions for Continued Airworthiness ICA-D350-604, revision 0, dated November 15, 2011, or later TCCA accepted revision.

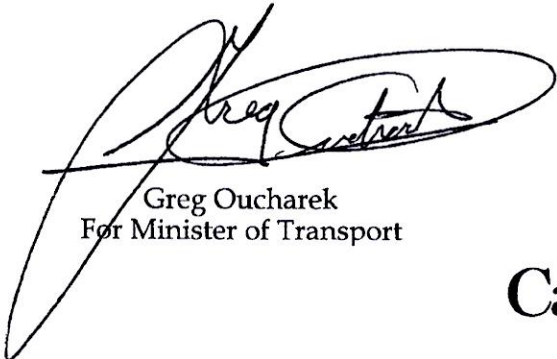
Definition of Type Design Change: TCCA approved Dart Aerospace Ltd. Master Document List MDL-D350-604, revision A, dated February 2, 2012, or later TCCA approved revision.

Basis of Certification for affected areas: 14 CFR, Part 27 at amendment 27-21.

— End —



Conditions: This approval is only applicable to the type/model of aeronautical product specified therein. Prior to incorporating this modification, the installer shall establish that the interrelationship between this change and any other modification(s) incorporated **will not** adversely affect the airworthiness of the modified product.


Greg Oucharek
For Minister of Transport

Canada